



Tri Tool Inc.
Technical Specification
Model CBM-3 COUNTERBORE MODULE KIT
January, 1995

MODEL CBM-3 COUNTERBORE MODULE KIT

The Model CBM-3 Counterbore Module Kit is a mechanical accessory to Tri Tool Models 616SB/636SB Clamshells and 614RBL/636RBL Clamshells. The Counterbore Module provides the capability to counterbore pipe after an in-line spool has been removed. The Counterbore Module kit mounts to Tri Tool's large SB series and RBL series tool blocks and is infinitely adjustable to allow any counterbore diameter consistent with the range of the specific clamshell.

Design and Operating Features:

1. Module can be mounted directly to the standard large 600SB and 600RBL tool blocks.
2. Manual axial feed.
3. Infinitely adjustable radial position.
4. No loose pieces.
5. Fits all schedules of 12" through 36" pipe on SB series clamshells.
Fits all schedules of 7" through 36" pipe on RBL series clamshells.
6. Accepts many tool bit styles.
7. Resetting of the clamshell is not required after severing in-line pipe. This assures that the counterbore will run perpendicular to the sever line and concentric to a sever and bevel cut for constant land thickness.
8. Easy access to the pipe bore allows counterbore diameters to be checked without removing any components from the clamshell.
9. Taper boring adjustment up to 30° chamfers or up to 30° lead out angles following a counterbore (maximum of 2"(50.8 mm) deep).

Specifications:

1. **Model CBM-3 Counterbore Module Kit. (Reference Drawing No. 77-0845)**

Height:	9.00"	(228.6 mm)
Width:	5.00"	(127.0 mm)
Length:	13.50"	(342.9 mm)
Weight:	22.0 lbs	(10.0 kg)

2. **Basic Pipe Sizes:**

12" through 36", all schedules (on the appropriate sized 616SB through 636SB Clamshell).
7" through 36", all schedules (on the appropriate sized 614RBL through 636RBL Clamshell).

3. **Counterbore Depth:**
 - a. **Up to 8.8"(223.5 mm) (less lead out angle) following a double bevel/sever operation.**
 - b. **Up to 8.6"(218.4 mm) (less lead out angle) following a right hand single bevel/sever operation.**

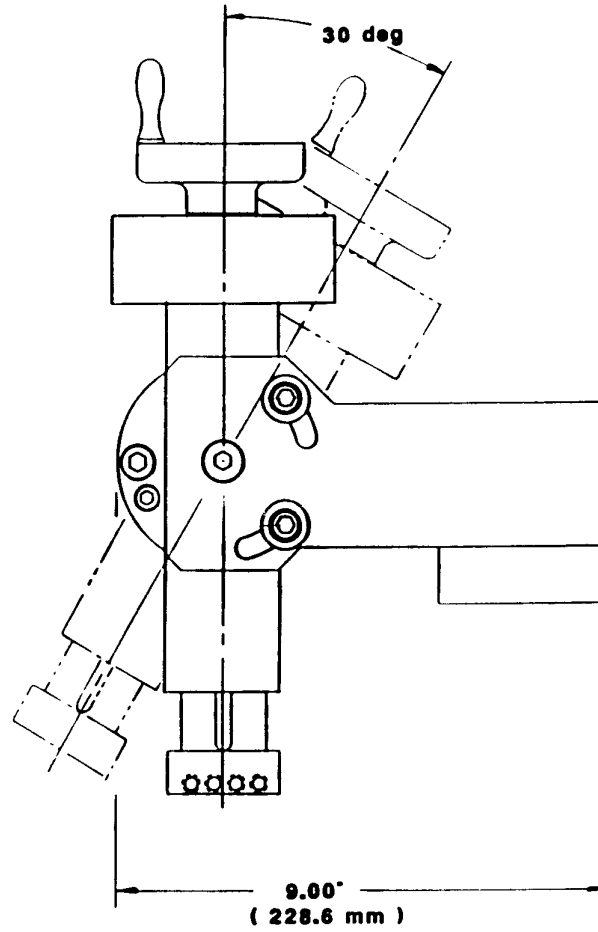
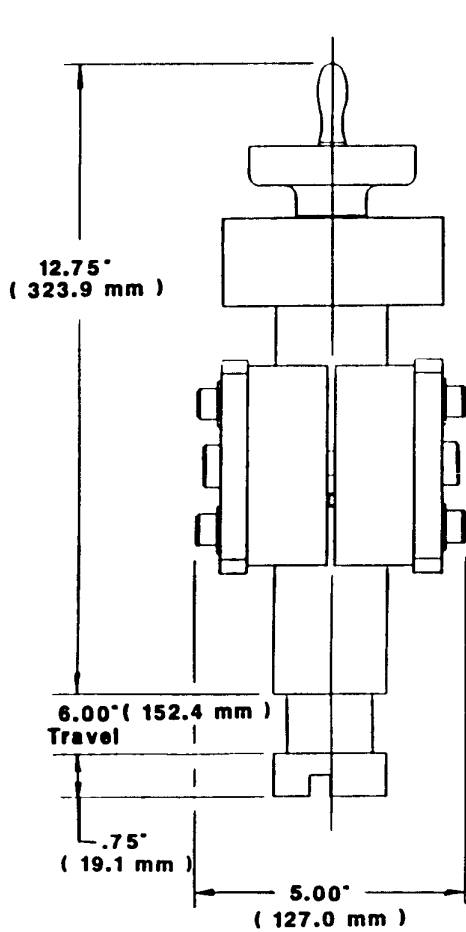
4. **Clearances:**
 - a. **Rotating parts diameter:** **Rotating diameter of Clamshell**
 - b. **Length (maximum):**

14.60"(370.8 mm) from the face of the Clamshell on 616SB/636SB
14.73"(374.1 mm) from the face of the Clamshell on 614RBL/636RBL

5. **Feed Length:** **6.0"(152.4 mm)**

6. **Axial Feed Rate:** **.010"(.25 mm)/revolution at full feed**

7. **Chamfer angle adjustment:** **0° to 30°**



NEXT ASSY		USED ON		STY	FORM	PART OR DESCRIPTION NO		QUANTITY	REVISIONS	INTERNAL SPECIFIC PART	
PARTS LIST											
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				MATERIAL FINISH		APPROVALS DRAWN PPAFMAN 5/25/97 CHECKED DATE		DATE		CBM-3 C'bore Module Kit	
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